Work Orde Thursday, Octob											Page
Revision ID:	D206 ² 642-54			Accept					Setup Sta	i ioriio i	
	10/28/2010	Start Qty: 1.00 Req'd Qty: 1.00			Cust Item I Customer:	D:				*	
Approvals:	Process Pla	n:	Date: <u>/ 0 - 10 - 2</u>	Tooling: SPC (Y/N):		ate:		I	Run Sta Sto	1 (88/118)	
Sequence ID/ Work Center ID)	Operation Description		Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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DC		Memo		0.00							

Photocopy bluefile & type labels per PPP D206-642-541

Document Control

N/ACX10/12/13

W/O:		WORK ORDER CHA		\$ 2	······································			
DATE	STEP	PROCEDURE CHANGE By Date				Approval Chief Eng / Prod Mgr	Approval QC Inspector	
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Part No:	PAR #:	Fault Category:	NCR: Yes No DQA:	Date:
Resolution: _		Disposition:	QA: N/C Closed:	Date:

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Thursday, October 28, 2010 10:14:50 AM

Item 1	ID٠

D206-642-541

Accept



Setup Start

Stop



Revision ID:

Item Name:

Replacement Skidtube

Start Date:

10/28/2010

Start Qty: 1.00

Required Date: 11/11/2010 Req'd Qty: 1.00



Cust Item ID:

Customer:

Reference:

Process Plan:

_____ Date:___

Date:

Tooling: SPC (Y/N): Date:

Date:

Run Start

Stop



Sequence ID/ **Work Center ID**

Operation Description

Set Up/ **Run Hours** Tool ID

Tool # Plan

Code

Accept Qty

Reject **Qty**

Reject Insp. Number Stamp

110



Skidtubes Skidtubes

Skidtubes

Memo

0.00

0.00

****VERIFY AND INSPECT THE MATERIAL PRIOR TO USE****

1- Bend FWD end of tube using bend prog D3274 FWD and foilo 10 as per dwg

D3274, cut fwd end of tube with saw table setup D3274. 2- remove fwd indexing ridge as per dwg D3274. Prepare for welding

3- weld fwd cap as per dwg D3274 and Q\$1004 AR Aluminum Rod Batch:

4- grind fwd cap weld on top surface only

5- Cut AFT end of tube at 170.9" as per dwg D3274 and deburr end.

6-Drill Aft cap pilot hole using DT8025

7 -Cleco DT8025 in position and install pilot hole drill Jig DT8742A,B,C,D. Drill 3/16" pilot holes as per Dwg D3274

8 -Remove inner indexing ridge on aft end of skidtube as per Dwg D3274 scribe batch #

9 -Open aft end cap holes to Ø0.208" as per Dwg D3274. Deburr aft end.

P10-10-28

BE 10.10-28

BE10-10-29

W/O:		WORK ORDER C	HANGES				
DATE	STEP	PROCEDURE CHANGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
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Part No):	PAR #: Fault Category:	NCR: Yes	No DQ	A:	Date: _	

Resolution: _____ Disposition: ____ QA: N/C Closed: ____ Date: ____

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Thursday,	October	28,	2010	10:



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Thursday, Octob	ber 28, 2010	10:14:50 AM										
Item ID: Revision ID:	D206-642-5			Accept				S	Setup	Start		***************************************
Item Name:	Replacement	Skidtube								Stop		
Start Date: Required Date:	10/28/2010	Start Qty: 1.00 Req'd Qty: 1.00			Cust Item 1 Customer:	ID:						
Reference:					Customer.							
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Sequence ID/ Work Center I	D	Operation Description		Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Rej Qty		Reject Number	Insp. Stamp
120	₫	Chemical Conversion Co	oat per QSI005 4.1	0.00				0				B /
HandFinish Hand Finishing	. *	Memo		0.00			,					14/09
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130		QC3- Inspect Part Finish	1	0.00	. *\							
QC Quality Control		Memo		0.00	• n /a (<u> </u>
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140		QC5- Inspect part comp	leteness to step on W/O	0.00								
QC Quality Control		Мето		0.00	why			(I)				-

W/O:		WORK ORDER CHANGES							
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Resolution: QA: N/C Closed: Date:

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Required Date: 11/11/2010



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Thursday, October 28, 2010 10:14:50 AM

D206-642-541

Accept



Setup Start



Revision ID:

Item Name:

Replacement Skidtube

Start Date:

10/28/2010

Start Qty: 1.00

Req'd Qty: 1.00



Cust Item ID:

Customer:

Tool ID

Reference:

Approvals:

Process Plan: _____ Date: ____

Tooling:

SPC (Y/N):

Date:

Date:

Tool # Plan

Code

Start Run

Reject

Qty

Accept

Qty

Stop

Stop

Insp.

Stamp

Reject

Number

Sequence ID/

Work Center ID

Skidtubes

Skidtubes

150

Operation Description

Skidtubes

Set Up/ **Run Hours**

0.00

Date:

0.00 Memo

1-Open Ø0.313" and 0.375" crossbolt spacer holes as per Dwg D3274

2-Deburr crossbolt spacer holes as per Dwg D3274 and blow out chips from inside the tube

3-Bond web in place as per Dwg D3274 & QSI 015.

A/R 🗆 Sikaflex-291 🗆 116090 Sikaflex expire date: 11-9-30
Start: 101116 Time: 14:00

Finish: 101817 Time: 91000

(Adhere for 12 hours)

10/11/10.

160

Quality Control

QC5- Inspect part completeness to step on W/O

Memo



0.00

W/O:		WORK	ORDER CHANGES		•	•.	**
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	Resolution:		Disposition:	QA: N/C Closed:	Date:

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Thursday, October 28, 2010 10:14:50 AM

D206-642-541

Accept



Setup Start

Stop

Stop



Revision ID:

Item Name:

Replacement Skidtube

Start Date:

10/28/2010

Start Qty: 1.00

Req'd Qty: 1.00 **Required Date:** 11/11/2010



Cust Item ID:

Customer:

Reference:

A	nn	ro	งภไ	6.

Process Plan: ____ Date:

Date:

Tooling:

Date:

Date:

Run Start



Sequence ID/

Work Center ID

Operation Description

Skidtubes

Set Up/ **Run Hours**

SPC (Y/N):

Tool ID

Tool # Plan

Code

Accept Reject Qty Qty

Reject Number

Insp. Stamp

170

Skidtubes

Skidtubes

0.00

Memo

0.00

1-Bend AFT end of tube using bend prog. D3274 AFT as per dwg D3274. Install drop pins in crossbolt spacer holes to maintain web position.

2- DRILL PILOT HOLES FOR WEARPLATES USING D3274-1T2 OPEN HOLES TO .297". Deburr

3-DRILL TOE PIN HOLE .640" DIA AS PER DWG USING DT8935 FWD END OF TUBE

DEBURR INSIDE OF HOLE AS NECESSARY (DO NOT ENLARGE HOLES) REMOVE ANY FOREIGN OBJECTS INSIDE OF TUBES

4- Countersink crossbolt spacer holes as per Dwg D3274

5- prepare for welding

180

QC5- Inspect part completeness to step on W/O

Memo

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Quality Control

W/O:	•		WO	RK ORDER CHANGE	=6	<u> </u>				
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Resolution:			_ Disposition	ı:	QA:	N/C Clo	sed:		Date: _	
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Item ID: Revision ID:	D206-642-54	41		Accept					Setup	Start	1 (886)(8) 8	
Item Name:	Replacement	Skidtube								Stop		
Start Date: Required Date: Reference:	10/28/2010 11/11/2010	Start Qty: Req'd Qty:	1		Cust Item Customer:							
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	QC:		Date:	SPC (Y/N):		Date:				Stop		
)	Operation Description		Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	t Rej Qty		Reject Number	Insp. Stamp
		Skidtubes Me		0.00								-
Skidtubes		1-lr D32 alur A/R 3-G	sert D2649 & D3275-1 74. Remember to back hinum rod □ □Aluminum Rod □ _ tind cross bolt welds flu	crossbolt spacers. Weld as per Q drill each hole before welding the	e other side. Use BE 10/11 3E 10/11/24	lub4 lub4	•					Pro
QC	•	QC5- Inspect pa	rt completeness to step o		- 7°	. , , , ,	(.	

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W/O:) No.	WORK ORDER CHANG	ES				
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Resolution: H work Disposition: Newsk

NCR: 6	3371	W	ORK OR	DER NON-CONFORMANCE	(NCR)	· · · · · · · · · · · · · · · · · · ·	<u>,,</u>	
7		Description of NC		Corrective Action Section B	Verification	Approval	Approval	
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Section C	Chief Eng	QC Inspector
10/11/24	# 190-1	Durring Back Drilling drike bit pulses (James) and course the cross bult space (D2649) to be come ovation. 4th hole for	1 Jusium	-> Drice out 4th holder (x-bult space) From APA: - Grino well off -> replace D 2649 B 63359+1	BEPUBY	Saubs	Josiun	colulay
. 3.		R.C. Process. (conty i since efector, weather)	1	-) reweld Asper Ostory	10/11/24	Solubs	Josiun	10/4/24
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Work Order ID 63371

Thursday, October 28, 2010 10:14:50 AM



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Item ID:

D206-642-541

Accept

Setup Start



Revision ID:

Item Name:

Replacement Skidtube

Start Date:

10/28/2010

Start Qty: 1.00

Required Date: 11/11/2010

Req'd Oty: 1.00



Cust Item ID:

Customer:

Reference:

di Approvals:

Process Plan: _____ Date:

Tooling:

Date:

Date:

Run

Start

Stop

Date:

SPC (Y/N):

Tool ID

Tool # Plan

Code

Accept Qty

Reject Qty

Reject Number Stamp

Sequence ID/ **Work Center ID**

210

Quality Control

Operation Description

QC10- Inspect visual per QSI004- ground welds

Set Up/

Run Hours

0 14/25

220

HandFinish Hand Finishing Pressure Wash per OSI005 4.3

Memo

=) W 10/11/26

Memo

0.00

Re-alodine tube as per QSI 005 section 4.1.2.1 do not acid etch

230

Powdercoat

Powder Coating

White Gloss(Ref:4.3.5.1) per OSI005 4.3-Alum

0.00

0.00

1 Bl10-11-29

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Accept

Work Order ID 63371 Thursday, October 28, 2010 10:14:50 AM D206-642-541 Item ID: **Revision ID:** Replacement Skidtube Item Name: 10/28/2010 Start Qty: 1.00 **Start Date: Required Date:** 11/11/2010 **Req'd Qty:** 1.00 Reference: Process Plan: _____ Date: ____ Tooling: **Approvals:** QC: _____ Date: ____ SP Sequence ID/ Operation **Work Center ID Description** 240 QC3- Inspect Part Finish



Setup Start



Cust Item ID:

Customer:

PC (Y/N):	D:	ate:	Sto	PP			
Set Up/	Tool ID	Tool #	Plan	Accept	Reject	Reject	Insp.
Run Hours			Code	Qty	Qty	Number	Stamp
0.00							

Date:

Memo

=) # 10/11/29 0.00

Start

Run

250 HandFinish

Hand Finishing

Quality Control

HandFinishing

10/11/29

1-Install Nut Plate as per Dwg D3274. Apply LPS-3 to Nut Plate and rivets. A/R \(\text{N/A} \(\text{LPS-3} \) \(\text{LM} \(\text{LOG 9.5} \) \(\text{6} \)

2-Install inserts as per Dwg D3274. Use a drop of Sikaflex inside insert holes a

Sikaflex expire date:

 $A/R \square \square Sikaflex-291 \square M / / S / / D \square$

11 (0 L

260 OC

Quality Control

QC5- Inspect part completeness to step on W/O

0.00

Memo

0.00

Inspect Nut Plate & Inserts

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W/O:			WO	RK ORDER CHANG	ES		· · · · · · · · · · · · · · · · · · ·		, ,
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Work Order ID 63371

Thursday, October 28, 2010 10:14:50 AM



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Item ID: D206-642-541 Accept Setup Start **Revision ID:** Item Name: Replacement Skidtube **Start Date:** 10/28/2010 Start Qty: 1.00 **Cust Item ID: Required Date:** 11/11/2010 **Reg'd Qty:** 1.00 **Customer:** Reference: Run Start **Approvals:** Process Plan: _____ Date: ____ Tooling: Date: Stop QC: _____ Date: ____ SPC (Y/N): Date: Sequence ID/ Operation Set Up/ Tool ID Tool # Plan Accept Reject **Work Center ID** Description **Run Hours** Code Qty Qty 270 => Il iolizaq HAND FINISHING RESOURCE #1 HandFinish 0.00 Hand Finishing 1-Install wearpads & gaskets as per Dwg D3274. 2-Install ring as per Dwg D3274 A/R \square Sikaflex-291 \square $N (15/14 \square \square$ D 11/01 Sikaflex expire date: 3-Inspect for foreign objects as per QSI 024 A-Spray inside of tube on both sides of web with LPS-3

A/R

LPS-3

Batch: V/A 5-Install Aft Cap and seal with Sikaflex. Clean excess adhesive.

280

QC

QC5- Inspect part completeness to step on W/O

0.00

Quality Control



Insp.

Reject Number Stamp

Sikaflex expire date:

Memo

0.00

BL/MM 10-12-9.

W/O:			W	ORK ORDER CHANC	NGES						
DATE	STEP	PRO	OCEDURE CH	ANGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector		
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Work Order ID 63371

Thursday, October 28, 2010 10:14:50 AM



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Item ID:

D206-642-541

Accept



Setup Start



Revision ID:

Required Date: 11/11/2010

Item Name:

Replacement Skidtube

Start Date:

10/28/2010

Start Qty: 1.00

Req'd Qty: 1.00



Cust Item ID:

Customer:

Reference:

Approvals:

Process Plan:

Date:_____

Tooling:

Date:

Run

Start

Stop

Stop



Date:

SPC (Y/N):

Set Up/

Run Hours

Date:

Reject

Insp.

Sequence ID/ Work Center ID

290

Packaging Packaging

Operation Description

Identify as per dwg & Stock Location:

0.00

0.00

Tool ID

Tool # Plan Code

Accept Qty

Qty

Reject Number Stamp

300

Quality Control

QC21- Final Inspection - Work Order Release

0.00

Memo

Memo

0.00

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W/O:			W	ORK ORDER CHANGE	ES				
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DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Section C	Chief Eng	QC Inspector
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Picklist Print Thursday, October 28, 2010 10:14:54 AM Work Order ID: 63371 Parent Item: D206-642-541 Parent Item Name: Replacement Skidtube Comments: IPP Rev:B□05.09.23□F IPP Rev:C 07-02-23 IPP Rev:D 07-12-06 IPP Rev:E 08-04-17 IPP Rev:F 08-06-02



Start Date: 10/28/2010

Required Date: 11/11/2010

Page 1

Start Qty: 1.00

Required Qty: 1.00

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IPP Rev:B□05.09.23□Revised per D206-642 Rev. J□F	√J/JLM

IPP Rev:C 07-02-23 Added SS Wearplates & Gaskets JLM□
IPP Rev:D 07-12-06 replace NAS1515H3L to D3672-1 DD
IPP Rev:E 08-04-17 as per PAR 08-015 DD verified by:EC
IPP Rev:G 08-10-09 revise details DD verified byEC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D2600-1-190		Manufactured	No			110	Each	63.0000	1	1			
				Location LG	47575 59874	<u>Loc</u>	Oty 63 15 48	Loc Code	[P	10-	10-	23
D3285-1		Manufactured	No		37074	110	Each	141.0000	1	1			
٠.				<u>Location</u>	!	Loc	<u>Oty</u>	Loc Code					
				LG	52511 52647		141 74 67		 _ _		- - Bt	F 10-10	-28
D3282-041		Manufactured	No	-	B63389	150	Each	0.0000	1	1			

563389

B 10/11/16.

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W/O:			WC	RK ORDER CHANGI	ES				,
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Picklist Print Thursday, October 28, 2010 10:14:54	AM									Page 2
Work Order ID: 63371 Parent Item: D206-642-541 Parent Item Name: Replacement Skidtu	ıbe						art Date: 1	10/28/2010	Required Date Required Qty	
D2649 Cross Bolt Spacer	Manufactured	No		190	Each	107.0000	12	12		
		<u>Locati</u> LG	58545 60652 61496 62889	Loc	Oty 107 2 4 13 88	Loc Code	G	6335	9 ×12	BE 10/11/29
D3275-1 Crossbolt Spacer	Manufactured	No		190	Each	216.0000	12	12		
		<u>Locati</u> LG	53453 61646 62399	<u>Loc</u>	216 8 102 106	Loc Code	Ċ	3	46 x9	· <i>& t</i> 5 14/124 0/11/24
CR3212-4-03	Purchased	No		250	Each	1,874.000	2	2	0111/29	<i>Julo 1</i>
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Picklist Print Thursday, October 28, 2010 10:14:54	4 <i>M</i>					·		Page 3
Work Order ID: 63371 Parent Item: D206-642-541 Parent Item Name: Replacement Skidtul	be		8			Start Date:	10/28/2010	Required Date: 11/11/2010
						Start Qty:	1.00	Required Qty: 1.00
D3415-041	Manufactured	No		250	Each	52.0000 1	1	lul 79
			Location	<u>Lo</u>	c Qty	Loc Code		
			ST056		52			-
CCD264882.2			33842	•••	52		X Z	_
CCR264SS3-3 Cherry Rivet	Purchased	No		250	Each	416.0000 2	2 Ju(oldeg
,			<u>Location</u>	Lo	c Qty	Loc Code		
			ST311		416			
			112314		4			_
			113539 <u>113973</u>		44	.	· · · · · · · · · · · · · · · · · · ·	_
ALS4-1032-130	Purchased	No	113973	250	368 Each	2,653.000 78	70	_
				230	Edeli		78 Jel	10/4/29
			Location	Lo	c Oty	Loc Code		
			PKG11		886			
			114723		886	1116049	X78	
			ST282		1728			_
			110511		10			

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W/O:			W	ORK ORDER CHANGE	ES				
DATE	STEP	PRO	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector		
Part No	•	PAR #:	Fault Cat	edory.	NCR: Yes	No. DO	Δ-	Date:	
		esolution:	4						
NCR:		,	WORK OR	DER NON-CONFORMA	NCE (NC	R)			
		Description of NC		Corrective Action Section	on B	Varifi		A 1	
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign Date	& Sec	cation tion C	Approval Chief Eng	Approval QC Inspector
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Picklist Print Thursday, October 28, 2010 10:14	:54 AM							Page 4
Work Order ID: 63371								g
Parent Item: D206-642-541 Parent Item Name: Replacement St	kidtube		8/8			Start Date: Start Qty:		Required Date: 11/11/2010 Required Qty: 1.00
D3536-15 Gasket	Manufactured	No		270	Each	18.0000 1	1 H1	olidoq
			Location FP 56055 60875 FP11 59238 62459	<u>L</u> .	6 1 5 12 1 11	Loc Code BG3568	<u> </u>	- - - -
D3536-23 Gasket	Manufactured	No		270	Each	3.0000 1	1 H	16/12/09
			<u>Location</u> FP011 61237	<u>L</u>	3 3	Loc Code B63238		· - -
D3536-35	Manufactured	No		270	Each	16.0000 1	1	16/12/09
			Location FP012 58683 61692 62462	L	16 1 3 12	Loc Code B 63579		
D3536-39 Gasket	Manufactured	No		270	Each	12.0000 1	1 Jel	10/10/09
			Location FP12 58215 58571	<u>L</u>	12 1 1 11	Loc Code B63578		
Thursday, October 28, 2010 10:14	1:54 AM		Shop Pa	cket Print				Page 4

Page 4

STEP	PR	WO	RK ORDER CHANGE	S By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
STEP	PR	OCEDURE CHAN	IGE	Ву	Date	Qty	Chief Eng /	Approval QC Inspector
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SIEP	Section A	Initial Chief Eng	Action Description Chief Eng		Sect		Chief Eng	QC Inspector
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		Resolution: Description of NC	Resolution: Disposition WORK ORDE STEP Description of NC Section A Initial Chief Eng	Resolution:	Resolution: Disposition: QA: N/C CI WORK ORDER NON-CONFORMANCE (NCF STEP Description of NC Section A Corrective Action Section B Sign 8 Chief Eng Ch	Resolution: Disposition: QA: N/C Closed: WORK ORDER NON-CONFORMANCE (NCR) STEP Description of NC Section A Corrective Action Section B Verification Chief Eng Chie	Resolution: Disposition: QA: N/C Closed: WORK ORDER NON-CONFORMANCE (NCR) STEP Description of NC Section A Corrective Action Section B Sign & Chief Eng	Description of NC Section A Description of NC Section A Chief Eng Chief En

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Picklist Print									Page 5
Thursday, October 28, 2010 10:14	:54 AM								
Work Order ID: 63371									9
Parent Item: D206-642-541									'
Parent Item Name: Replacement Sk	kidtube	\$ C DB (818	1919 11911 60(18 9411 119919 93111 91919 1191 119	421 BIIII BIBAI IIBI 181	•1	S	tart Date:	10/28/2010	Required Date: 11/11/2010
	· . • .	n.				5	Start Qty:	1.00	Required Qty: 1.00
D3535-15	Manufactured	No		270	Each	22.0000	1	1	
Wearshoe								HL	10/12/09
			Location	Lo	c Qty	Loc Code			
			FP18		22				<u> </u>
•			61241 62241		6				
			627 <u>07</u>		3 13			- X (<u> </u>
D3535-35	Manufactured	No		270	Each	26.0000	1	1	
Wearshoe								Jel 1	4011210
			Location	Lo	c Oty	Loc Code			
			FP018		26				
			60865		6				
			62461		12 8				<u> </u>
D3535-39	Manufactured	No	<u>62969</u>	270	o Each	27.0000	1	1	
	ivianuiaciuieu	110		210	Lucii	27.0000		Ju v	10112109

Wearshoe

Loc Qty

27

16

11

Loc Code

Location

60233

62945

FP18

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DATE	STEP	PRO	OCEDURE CHAI	NGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
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		esolution:							
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DATE	STEP	Description of NC	Initial		ion B		cation	Approval	Approval
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Work Order ID: 63371					<u> </u>						
Parent Item: D206-642-541											
Parent Item Name: Replacement Ski	idtube	1 (4 8) (1)	ITO ILOIA OBIAN DAILA				\$	tart Datas	10/28/2010	Required Date:	11/11/2010
•								Start Qty:		Required Qty:	
D3535-23	Manufactured	No			270	Each	28.0000	1	1	1 C - 3	
	TVIAITATACTAT CA				_,,	3	20.0000		JU.	10/12/09	
			Location	!	Lo	c Qty	Loc Code				
			FP			7					
				61830		6					
			FP021			21					
				60231		8			- 1/1		
D3537-3	Maria Carlo	NI-		62706	270	13	40.0000		<u> </u>		
	Manufactured	No			270	Each	40.0000		lil	10/12/09	·
			Location	Į.	<u>Lo</u>	c Oty	Loc Code				
			FP17			40					
				60866		3					
				61674		17					
				62705		20			<u> </u>		
D3537-1	Manufactured	No			270	Each	66.0000	9	9		
Wearpad									ر لىل	0112109	
			Location	Į.	<u>Lo</u>	c Qty	Loc Code				
			FP			1	B638	54 <i>S</i>	19		
				55465		1	26-3				_
			FP017			59	(A)	ı			<i>f</i>
				61986		15					
				62209		44					
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								Prod Mgr			
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Work Order ID: 63371										
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Parent Item Name: Replace	ement Skidtu	be				.		t Date: 1	10/28/2010	Required Date: 11/11/2010 Required Qty: 1.00
AN960C10L NA	S1149C0332	Purchased	No		270	Each	29.0000	80	80	
washer									01 10	112/09
waster .				Location	<u>Lo</u>	c Oty	Loc Code			
AN960C416 <u>N</u> A	S1149C0463	Donalossad	No	ST245 107534	270	29 29 Each	X11158	32	x <i>§</i> 0	<u>.</u> -
R_		Purchased	NO		270	Each			Il	10112109
washer				Location ST346	<u>Lo</u>	<u>e Oty</u> 30	Loc Code 入八しらる	5 8	χl	
				100993		30	·			- -
D3672-1		Manufactured	No		270	Each	847.0000	2	2.	

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Manufactured

Location

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Loc Qty 847 150 697

Loc Code

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W/O:			WC	RK ORDER CHANGE	ES				و ادن
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Picklist Print Thursday, October 28, 2010 10:1-	4:54 AM									Page 8
Work Order ID: 63371										
Parent Item: D206-642-541										
Parent Item Name: Replacement S	Skidtube		I n (1811 66)(8 6)(1	******		!!!		art Date: :	10/28/2010 1.00	Required Date: 11/11/2010 Required Qty: 1.00
AN3C4A BOLT	Purchased	No			270	Each	2,233.000	80	80 JJJ 10	olizlog
			Location	<u>n</u>	<u>L</u>	oc Oty	Loc Code			
			ST303			3		•		_
				115438		3				_
			ST350			2230				_
				114108		14				_
				114416		12				_
				114523		2				
				115300 115589		202 1000				_
				115936		1000			X80	
AN4C5A	Purchased	No		115750	270	Each	481.0000	1	1	_
BOLT	i uichascu	710			270	Lacii	481.0000		<u>_</u> <u></u>	10/12/09
			Location	<u>n</u>	L	oc Qty	Loc Code			
			ST346			481			****	_
				110552		4				_
				112243		477			χ/	
D2646	Manufactured	No			270	Each	45.0000	1	1	
Aft Cap									_JY	10/12/09
			Location	<u>n</u>	, <u>L</u>	oc Qty	Loc Code			
			FP-4			35				
				573 <u>32</u>		35			<u> </u>	_
			fp5	-		6				
			=	62652		6				_
			FP6			4				
				52663		4				_

W/O:		WORK ORDER CHA	ANGES				
DATE	STEP	PROCEDURE CHANGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
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Part No	:	PAR #: Fault Category:	NCR: Yes	No DQ	A :	_ Date: _	

NCR:		WORK ORDER NON-CONFORMANCE (NCR)										
		Description of NC		Corrective Action Section B		Verification	Approval	Approval				
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Section C	Chief Eng	QC Inspector				
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Thursday, October 28, 2010 10:14:54 AM

Work Order ID: 63371

Parent Item:

D206-642-541

Parent Item Name: Replacement Skidtube



Start Date: 10/28/2010

Required Date: 11/11/2010

Page 9

Start Qty: 1.00

Required Qty: 1.00

D3413-1

Ring

Manufactured

No

270

Loc Qty

23

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15

Each 23.0000

Loc Code

Location ST473 51586 53446 61322

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			Disposition:			QA: N/C Closed:				
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DESIG	CP	DRAWN BY	DART AEROSPACE USA, INC.
CHEC	(ED J	APPROVED 4	DRAWING NO. REV. D
	#	-#	D3274 SHEET 1 OF 4
DATE			TITLE SCALE
06.1	2.19		SKIDTUBE ASSEMBLY NTS
Α		04.03.15	NEW ISSUE
В		04.08.09	MOVE SADDLE HOLE: 42.14 WAS 42.76
С		05.03.16	ADD -043; NEW INSERTS
D		06.12.19	NEW INSERTS, SS WEARSHOE + GASKET

	Qty -041	Qty -043	Part Number	Description
	Х		D3274-041	SKIDTUBE ASSEMBLY
		Х	D3274-043	SKIDTUBE ASSEMBLY
	1	1	D2600-1-240	EXTRUSION
	1	1	D2646	AFT CAP
	12	12	D2649	CROSS BOLT SPACER
	12	37	D3275-1	CROSS BOLT SPACER
*	1	1	D3282-041	FLOAT WEB
	1	1	D3285-1	CAP
	1	1	D3413-1	RING
	1	1	D3415-041	NUT PLATE
	1	1	D3535-15	WEARSHOE
	1	1	D3535-23	WEARSHOE
	1	1	D3535-35	WEARSHOE
	1	1	D3535-39	WEARSHOE
	1	1	D3536-15	GASKET
	1	1	D3536-23	GASKET
	1	1	D3536-35	GASKET
OP COPY	1	1	D3536-39	GASKET
TURN TO	9	9	D3537-1	WEARPAD
INEERING	1	1	D3537-3	WEARPAD
ROLLED COPY	78	78	ALS7-1032-130	INSERT (or AKS4-1032-130, ALS4-1032-130, AELS-1032-130)
O AMENDMENT	80	80	AN3C4A	BOLT
	1	1	AN4C5A	BOLT
OUT NOTICE	1	1	AN960C416	WASHER
K ORDER	80	80	AN960C10L	WASHER
<u> 337/</u>	2	2	CCR264SS3-3	RIVET
	· 2	2	CR3212-4-03	RIVET
2810-10-26	2	2	NAS1515H3L	WASHER

GENERAL NOTES:

\$HOP COPY RETURN TO **ENGINEERING** UNCONTROLLED COPY SUBJECT TO AMENDMENT WITHOUT NOTICE WORK ORDER

- 1. TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.
- 2. DAMAGE TOLERANCE ON FWD BEND:

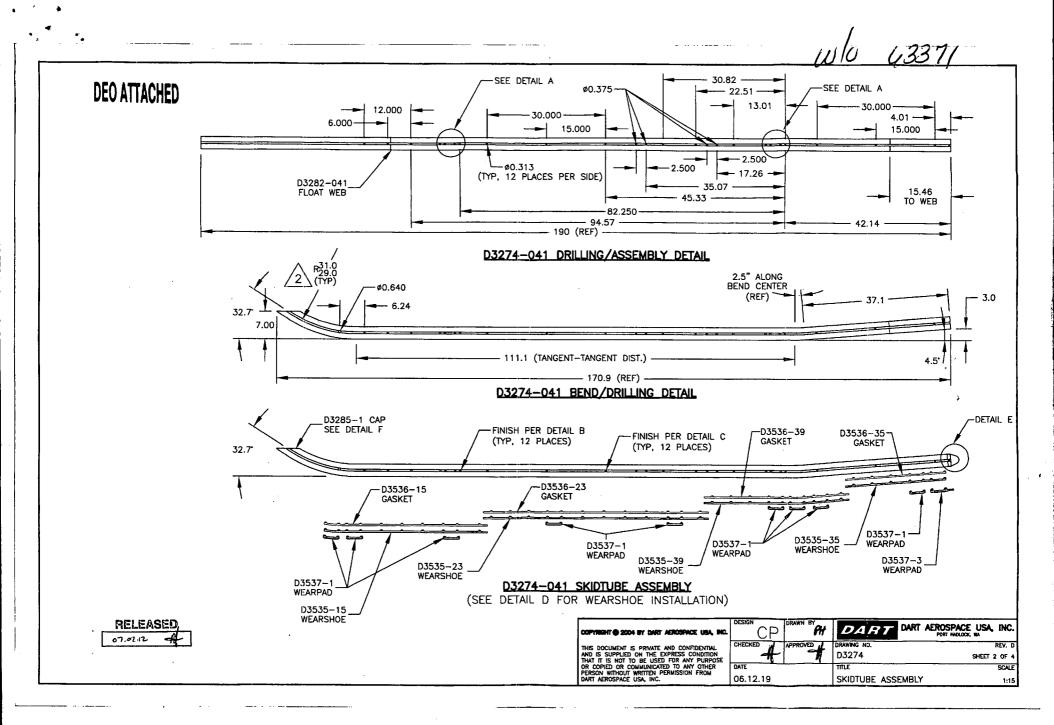
THERE SHOULD BE NO VISIBLE WRINKLES IN THE BEND FROM THE GROUND TO A HEIGHT OF 7 INCHES ABOVE THE GROUND. IT IS ACCEPTABLE TO POLISH OUT GOUGES UP TO 0.020 DEEP IN THE BENT PORTION OF THE TUBE. A MAXIMUM REDUCTION IN DIAMETER OF 0.150" IS ACCEPTABLE IN THE BENT PORTION OF THE TUBE.

- 3. ALL HOLES DRILLED ON CENTERLINES.
- 4. BOND D3282-041 FLOAT WEB INTO D3274-1/-3 OUTER TUBE WITH NON-STRUCTURAL SIKAFLEX-241/291 ADHESIVE PER DART QSI 015. ENSURE HOLES LINE-UP.
- 5. WELDING TO BE DONE PER DART QSI 004.
- 6. FINISH: ACID ETCH, ALODINE ASSEMBLY PER DART QSI 005 4.1 POWDER COAT WHITE (REF. 4.3.5.1) PER DART QSI 005 4.3
- 7. DRILL Ø0.297 HOLES FOR ALS7-1032-130 INSERTS USING DT3274-1T2 BEFORE FINISH. INSTALL ALS7-1032-130 INSERTS AFTER FINISH. SEAL WEARSHOE BOLTS WITH SIKAFLEX -241/-291.
- 8. SPRAY INSIDE OF TUBE WITH A COAT OF LPS LABORATORIES "LPS-3" AFTER FINISH AND INSTALLATION OF INSERTS. COAT ALL EXPOSED FASTENERS WITH LPS LABORATORIES "LPS PROCYON" AFTER FINAL ASSEMBLY, CLEAN EXCESS OFF POWDER COATING WITH MEK DEGREASER.

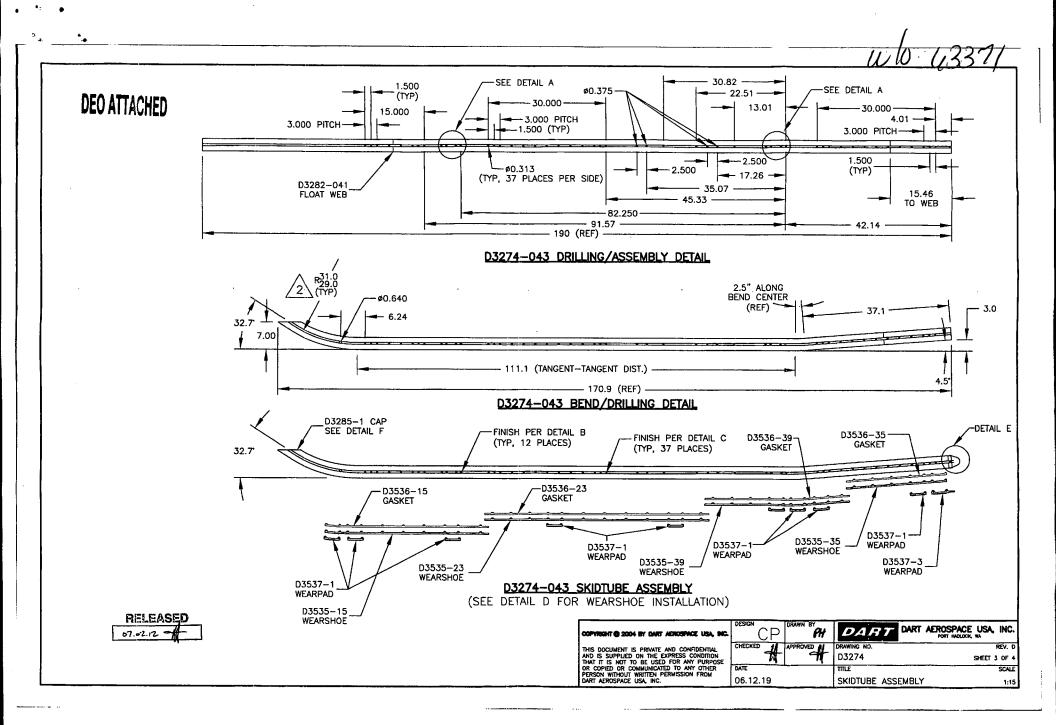
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Dart Ae	rospace	e Ltd						
W/O:			٧	VORK ORDER CHANGE	S			
DATE	STEP	PROC	IANGE	Ву	Date Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	
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Part No		PAR #:						* *
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DATE	STEP	Description of NC Section A	Initial Chief Eng	Corrective Action Section Action Description Chief Eng	Sign & Date	Verification Section C	Approval Chief Eng	Approval QC Inspector
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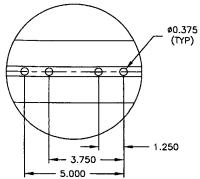


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D.4.T.E.	0750	Description of NC		Corrective Action Section B			ication	Approval	Approval
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign Date	& Sec	tion C	Chief Eng	QC Inspector
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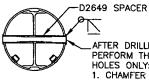


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DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign 8 Date	Secti		Chief Eng	QC Inspector
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DETAIL A: DRILL DETAIL



DETAIL B FOR Ø0.375 HOLES ONLY

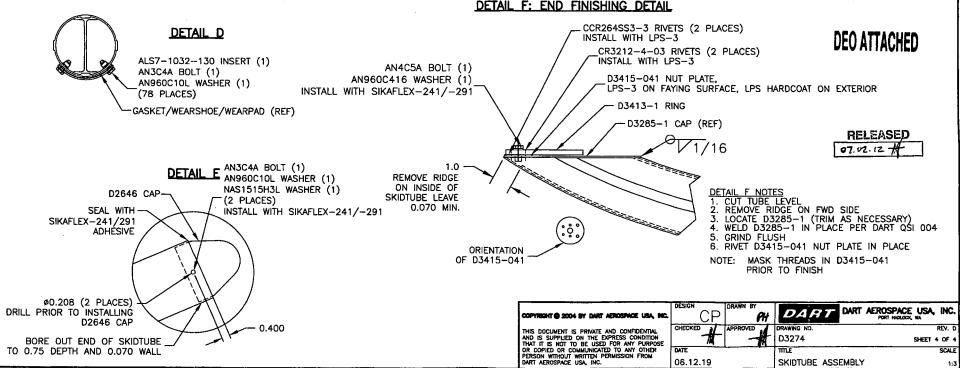


AFTER DRILLING AND BENDING ASSEMBLY PERFORM THE FOLLOWING FOR Ø0.375 HOLES ONLY:

- 1. CHAMFER HOLE 0.030x45°
- 2. INSERT D2649 SPACER
- 3. WELD INTO PLACE AND GRIND FLUSH
- 4. C'BORE TO Ø0.313x0.75 DEEP

DETAIL_CFOR Ø0.313 HOLES ONLY -D3275-1 SPACER CHAMFER 0.030x45* (TYP)

DETAIL F: END FINISHING DETAIL



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Dart Ae	rospace	e Ltd		•						• ••
W/O:			V	VORK ORDER CHAN	IGES					2
DATE	STEP	PRO	CEDURE CH	HANGE		Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
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	R	esolution:	_ Disposit	tion:	QA:	N/C Clos	sed:		Date: _	
NCR:		W	ORK OR	DER NON-CONFORM	MANCE	(NCR)				
DATE	STEP	Description of NC			Section B		Verification		Approval	Approval
DAIL	SIEF	Section A	Initial Chief Eng	Action Description Chief Eng	n	Sign & Date	Section C		Chief Eng	QC Inspector
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DRAWING		TITLE		REV. D	DART AEROSPACE USA,	INC D.E.O. NO.		SHEET NO.	SCALE
D3274		SKIDTUBE A	SSEMBLY		ENGINEERING ORDER	D3274-D	-1 ()	SHEET 1 OF 1	NTS
DRAWN	<u> (1)</u>		CHECKED	B	MFG. APPR.	APPROVED	NAP.	DE APPR.	
DATE	09.06.	17	DATE 09.06.	23	DATE 59/06/23	DATE	09/06/23	DATE 09 06 23	

LPS-3 IS NO LONGER USED DURING ASSEMBLY OF SKIDTUBE.

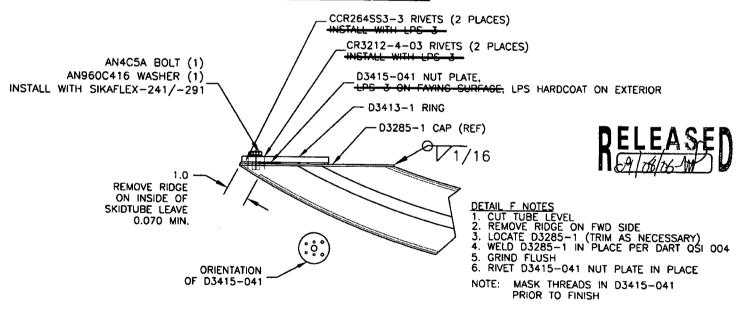
AMEND NOTE 8: "SPRAY INSIDE OF TUBE WITH A COAT OF LPS LABORATORIES 'LPS 3' AFTER FINISH AND INSTALLATION OF INSERTS.

COAT ALL EXPOSED FASTENERS WITH LPS LABORATORIES 'LPS PROCYON' AFTER FINAL ASSEMBLY, CLEAN EXCESS OFF POWDER COATING WITH MEK DEGREASER."

AMEND DETAIL F AS SHOWN:

wlo 63371

DETAIL F: END FINISHING DETAIL



Dart .	Aeros	pace	Ltd
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W/O:			-	WORK ORDER	R CHANGES					م د د
DATE	STEP	`	PR	OCEDURE CHANGE		Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
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Part No: _	PAR #:	Fault Category:	NCR: Yes No DQA:	Date:
	Resolution:	Disposition:	QA: N/C Closed:	Date:

NCR:1		W	ORK OR	DER NON-CONFORMANCE	(NCR)			
V		Description of NC	Corrective Action Section B			Varification		A
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Verification Section C	Approval Chief Eng	Approval QC Inspector
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AWS D17.1.2001 QUALIFICATION TEST RECORD

Name: Barclay Elliott		
Job number: 622800		
Part number: DROG 642 . 541		
Description: 206 5kid		
Welding Process: Tig Mig]		٠.
Base materiel: Aluminia	, *	
Current: AC[/] DC[]		

TEST REQUIREMENTS AND RESULTS

Visual: Penetration:	pass[i] fail[] pass[] fail[]
UNACCEPTABLE	
Cracks: Undercut: Pin holes: Overlap (cold lap) Porosity (surface): Coloration:	pass[] fail[] pass[] fail[] pass[] fail[] pass[] fail[] pass[] fail[] pass[] fail[]
Qualifier DID	Date of Test Coupon 10.09.30 Date of Test Coupon 10.09.30
4	

The above named individual is qualified in accordance with AWS D17.1.2001 to weld.